

Date: Tuesday, 02/10/2007 12:53:40 PM
User: Linda Laclelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ARM		
Job Number	: 34964					
Estimate Number	: 12578					
P.O. Number	: N/A		Part Number	: D3560041		
This Issue	: 02/10/2007	S.O. No.	: N/A	Drawing Number	: D3560 UNDER REVIEW	
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: B		
Previous Run	: 34474		Material	: N/A		
Written By	:		Due Date	: 09/10/2007		
Checked & Approved By	:		Qty:	5 Um: Each		
Comment	: Est Rev.A New Issue 07.05.24 EC					

Additional Product

Job Number:



Seq #:	Machine Or Operation:	Description :
1.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		
Comment: LARGE FABRICATION RESOURCE 1		
PULL FROM STOCK:		
2.0	D3560041	ARM WELDMENT
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)		
ARM WELDMENT B 32643 = 5 334478-3 334260 = 2		
3.0	D35921	PLATE
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)		
PLATE 334478-3 334260 = 2		
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		
Comment: LARGE FABRICATION RESOURCE 1		
1-Weld assembly as per dwg D3560		
5.0	QC5	INSPECT WORK TO CURRENT STEP
		
Comment: INSPECT WORK TO CURRENT STEP		

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Drawing Name: ARM

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

① 07-10-03 ⑤

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

② M 07-10-03

③ 7/10

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

④ E

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

⑤ 07-10-03

⑥ 5

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: WA

⑦ 07-10-03

⑧ 5

11.0 QC21 FINAL INSPECTION/W/O RELEASE



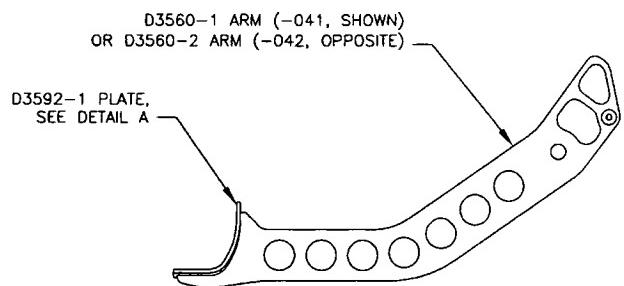
Comment: FINAL INSPECTION/W/O RELEASE

⑨ 07-10-03

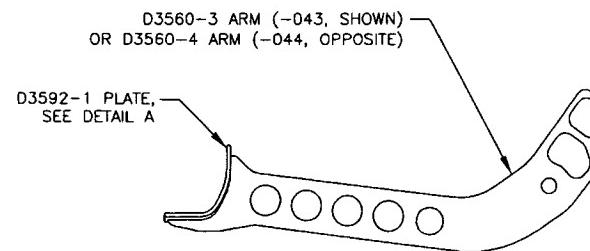
Job Completion



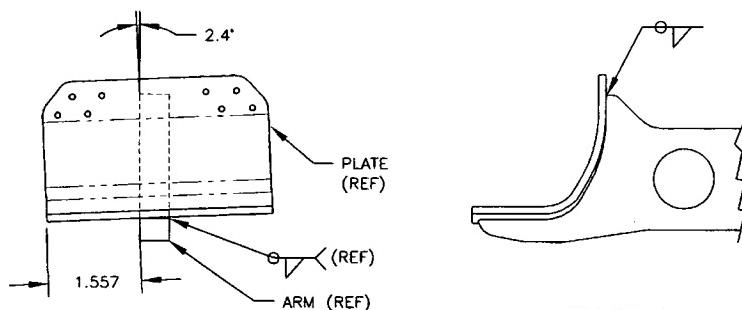
⑩ 07-10-04



D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
07.06.19

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DESIGN	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DRAWN BY	9P	DART
CHECKED	H	APPROVED
DATE	07.06.19	TITLE ARM WELDMENT
		SCALE 1:4

DART AEROSPACE LTD.
HAWKSBURY, ONTARIO, CANADA
REV. C
SHEET 1 OF 3

